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PRESS DIE FOR HEMMING

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ABSTRACT

PURPOSE: To execute the hemming work without causing fall of the vertical wall of outer panel and to improve the beautiful appearance of the pressed products by providing the 1st pre-bending surface and the 2nd pre-bending surface on the pre-bending blade.

CONSTITUTION: In the 1st pre-bending, at the time of pressing the outer panel 21 and the inner panel 22 with the core metal, by pressing the flange part 21a of the outer panel 21 from outside with the 1st pre-bending surface 51a, this flange part 21a is sent along the core metal to the inner panel 22 side. In the 2nd pre-bending, after the core metal is retreated, the flange part 21a bent with the 1st pre-bending is sent to the inner panel 22 side so that the vertical wall of the flange part 21a is pressed to the step part 31a of the lower die 31 with the 2nd pre-bending surface 51b.

